

9143217

Date: Wednesday, 3/8/2006 10:38:55 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLANGE PLATE
Job Number	: 26132 -2	Part Number	: D34781
Estimate Number	: 12173	Drawing Number	: D3478 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 3/31/2006
Previous Run	: N/A	Qty:	10/6 Um: Each
Written By	: <u>See comment below</u>		
Checked & Approved By	: <u>06/03/08</u>		
Comment	: Est Rev:A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O 00000768 06/03/09  
E-mail or Ship DXF file to vendor  
Laser cut flat pattern as per Dwg D3478  
Possible supplier: Ind. Laser  
Material release note is required.

2.0	D34781F	FLANGE
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3478 using Dt8848 A&B

SB 06/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One taken for template	1	2003/28		<i>[Signature]</i>	<i>[Signature]</i>

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 06/04/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 3/8/2006 10:38:55 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE PLATE

Job Number: 26132

Part Number: D34781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*1/26/04-06* (5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*LD 06/04/06* (8)

Job Completion



*u 06-04-06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector




Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

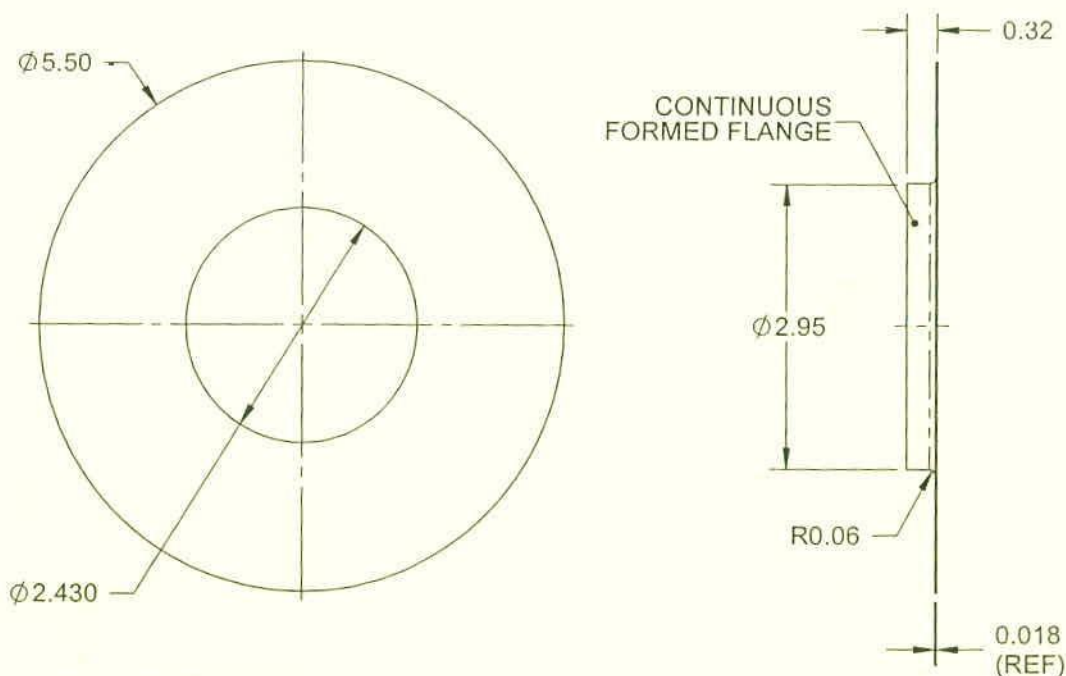
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED 	DRAWING NO. D3478	REV. A SHEET 2 OF 3
DATE 05.12.08		TITLE AIR INLET ADAPTER	SCALE 1:2



**D3478-1F FLANGE**  
**FLAT PATTERN**

**D3478-1**  
**FLANGE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010





AK Steel		Metallurgical Test Report		Coshcon, OH 43812	
<b>AK Steel Corporation</b> Coshcon Works Coshcon, OH 43812		Lead No. 741672 SRN No. 741672		Page 1	
<b>INTRODUCED METALS</b> 306 B STEEL ALBANY, WA 98001		<b>PROCESSED ORDER NO.</b> 77135-01 <b>PROCESSED ORDER NO.</b> 42715-01 <b>ORDER NO.</b> 77135-01 <b>ORDER NO.</b> 42715-01		<b>EXAMINATION - PRODUCT - METALLOGRAPHY</b> 77135-01 42715-01	
<b>SKID ID</b> 1 <b>PIECE</b> 1 <b>HEAT</b> 77135-01 <b>PARENT COIL ID</b> 77135-01 <b>NET WEIGHT</b> 4012 KG.		<b>SKID ID</b> 1 <b>PIECE</b> 1 <b>HEAT</b> 77135-01 <b>PARENT COIL ID</b> 77135-01 <b>NET WEIGHT</b> 4012 KG.		<b>SKID ID</b> 1 <b>PIECE</b> 1 <b>HEAT</b> 77135-01 <b>PARENT COIL ID</b> 77135-01 <b>NET WEIGHT</b> 4012 KG.	
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INDUSTRIAL LASER P.O. - 110880 S.O. - 374786 ITEM 01 - 3 SHTS

3/17/06

604-546-453 ATN: JETE





## Fax Server

T-728 P.008/015 F-537

03/17/2006 14:18 FAX 6042729137



## MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 1  
Heat/Lot : 86K9  
TIN : B42748

Sold To: INTEGRIS METALS, LTD.  
7910 40TH STREET SE  
CALGARY, AB T2C2Y3

Ship To: \*\*\*CUSTOMER PICKUP\*\*\*  
4375 14TH STREET NORTHEAST  
CALGARY  
ABT3E7A9

### Vendor Information

Cust PO #: 416824

Cust PO DT: 11/03/05

### Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/04a 480/04a, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04  
Q08766D-A X HG FRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS  
CORROSION: ASTM A262/02aE; 180Bend-OK  
Buyer Part: 4288441  
304 2B .1305 IN 48 IN 96 IN  
Country of Origin: UNITED STATES

### Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

### Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

### Comments





# MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN  
740 IMPERIAL ROAD NORTH

Page : 2  
Heat/Lot : 86K8  
TIN : B42748

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A  
This document certifies the material has been tested in  
accordance with applicable specifications described herein  
and has met those requirements.

QA by ERIC HESS 02/01/2006

## Miscellaneous Data

GUKLPH, ONN K123  
Control #: 50C60214  
Part #: 74271441  
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDIAN LAKE

TO 110880

S/O 90-374786 - 02

*[Signature]* 3/17/06

The Chemical Analysis and Mechanical Test  
data was received via EDI from the above  
mentioned vendor.

INTEGRIS METALS, LTD.

